

Ship body Aug 3

Work Order ID 88778

88778

Page 1

August-03-12 6:35:27 AM

Item ID: DSI 9464-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Tuning

Start Date: 8/03/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3955	A
DSI 9464	B

100

0.00

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

0.00

DAS 16 2/8/13 12/08/03

MLJ 12/08/03

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

1 12/08/03 JB

Work Order ID 88778

88778

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Item ID: DSI 9464-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube Tuning
 Start Date: 8/03/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
130 *130* Packaging Packaging	Memo Identify and pack for shipping as per PPP DSI 9464-011 Location: _____ PPP rev: <u>541P</u>	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12/8/03 (11)

MLJ 12/08/03

MLJ 12/08/03

Picklist Print

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Work Order ID: 88778

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 8/03/12

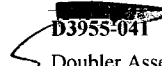









Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
10.04.19 verified by:EC

IPP Rev:B as per ECN10-553 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D3955-041 Doubler Assembly		Manufactured	No			110	Each	11.0000	 2	2	JB		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		11							
				83349		11				83349			
 D3955-3 Cover Plate		Manufactured	No			110	Each	10.0000	 2	2	JB		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST077		10							
				83350		10				83350			
 D3955-5 Plate		Manufactured	No			110	Each	12.0000	 2	2	JB		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST077		12							
				82617		5				82617			
				83352		7							
 D3955-7 Plate		Manufactured	No			110	Each	7.0000	 6	6	JB		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST071		7							
				83290		7				83290			
 D3955-21 Gasket		Manufactured	No			110	Each	14.0000	 2	2	JB	12/08/03	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		4							
				80623		4				80623			
				ST077		10							
				83353		10							

Picklist Print

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Work Order ID: 88778

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 8/03/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3955-23

Template

Manufactured No

110 Each 7.0000

2

2

Location

Loc Qty

Loc Code

ST077

7

83306

7

83306

Purchased No

110 Each 3,803.0000

38

38

Location

Loc Qty

Loc Code

ST331

116

116471

36

117816

3

118686

1

118840

16

119017

60

st510

3687

119075

3687

119075

Purchased No

110 Each 1,187.0000

4

4

Location

Loc Qty

Loc Code

ST350

1187

115371

46

117423

121

119355

200

120187

314

121185

6

122416

500

120187

Purchased No

110 Each 203.0000

4

4

Location

Loc Qty

Loc Code

ST351

203

117441

34

120644

19

121060

50

121166

100

120644

CR3212-4-04

Cherry Rivet

AN3-SA

Bolt

AN3-6A

Bolt

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Shop Packet Print

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Work Order ID: 88778

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 8/03/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

AN3-7A
Bolt

Purchased No

110 Each 93.0000

4

4

✓ JB

✓

Location

Loc Qty

Loc Code

ST351

93

117872

21

121444

72

121444

AN3-10A
Bolt

Purchased No

110 Each 65.0000

4

4

✓ JB

✓

Location

Loc Qty

Loc Code

ST351

65

117795

2

120873

63

120873

NAS1149D0332J
Washer

Purchased No

110 Each 896.0000

6

6

✓ JB

12/08/03

✓

Location

Loc Qty

Loc Code

ST297

679

121708

679

121708

ST298

217

105793

12

110985

4

117087

89

119042

16

119717

65

120644

7

121011

24

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Work Order ID: 88778

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 8/03/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

MS21042113

Nut

Purchased

No

110

Each

3,575.0000

2

2

12/08/03

Location

Loc Qty

Loc Code

316

839

122452

839

ST300

832

117885

32

119017

654

119075

138

121444

8

ST317

1904

122141

1904

122141

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Shop Packet Print

Page 4

DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skidtube in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skidtube.

Procedure:

Note: Installer must be careful not to damage underlying skidtube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skidtube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skidtube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skidtube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skidtube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skidtube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:

The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	DSI 9464	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

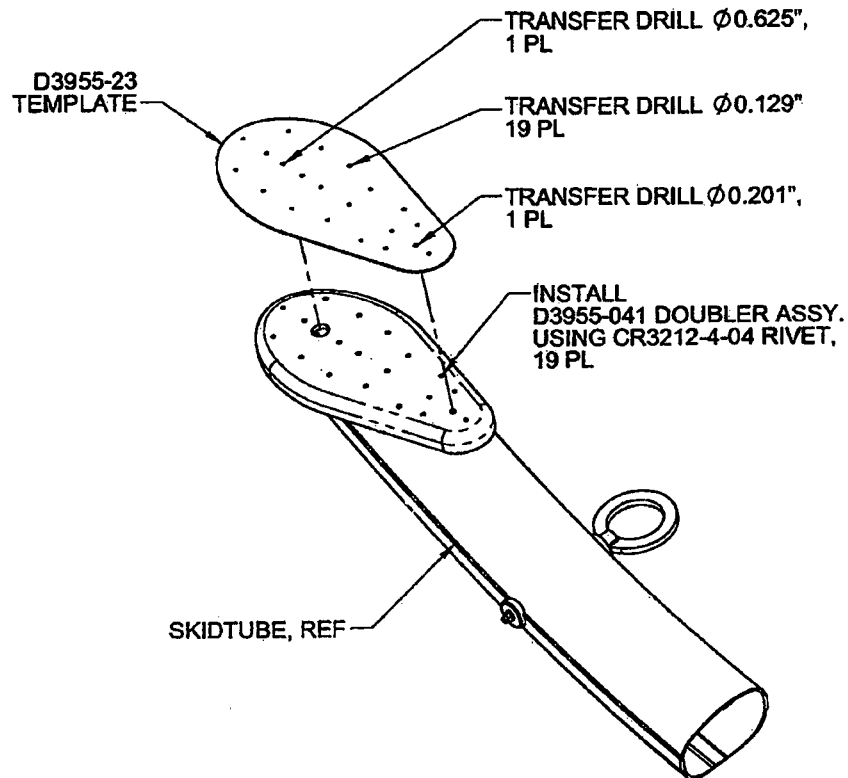


Figure 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	NIA	DSI 9464	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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REFERENCE ONLY

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

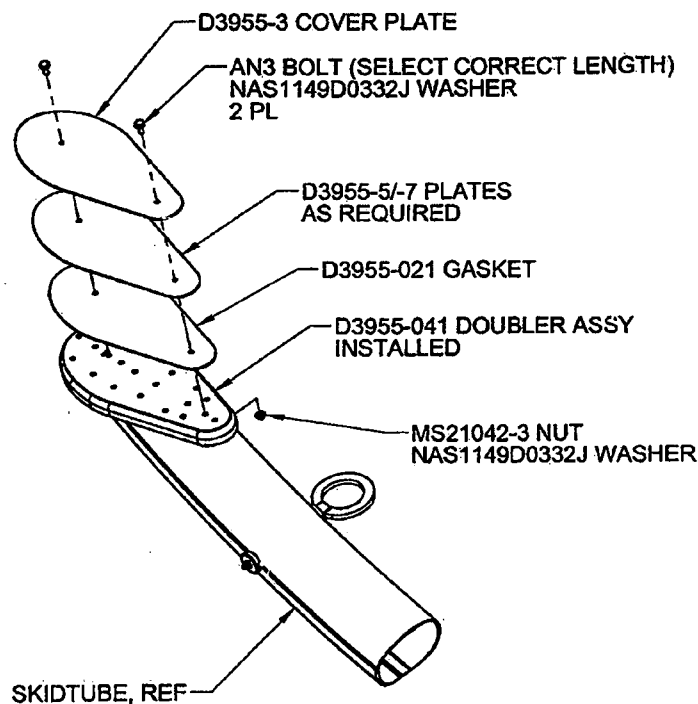


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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